

Split Rush

Sub Nov 29

Work Order ID 153190 -1

Wednesday, November 09, 2016 12:45:00 P

647.7501

153190

Page 1

Item ID: 647.7501

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 11/10/2016 Start Qty: 4.00

Required Date: 11/15/2016 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: VS

Date: 11/11/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.7500

A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

NOV 23 2016

DAS
6
9-89

120

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598:

exp. date: 04/18/135479

IX

11/11/24

DAS
36
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

DAS
38
9-89

NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Work Order ID 153190

Wednesday, November 09, 2016 12:45:00 P

153190

Page 2

Item ID: 647.7501

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Cutter Assembly

Start Date: 11/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/15/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CC K001</u>	0.00					DAS 6 9-89		
140									
Packaging	Memo	0.01							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89 NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Wednesday, November 09, 2016 12:45:07 PM

Page 1

Work Order ID: 153190

153190

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813 *647 7813* Center Plate, Lower		Manufactured	No				Each	9.0000		4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK114			9					
					<u>147215</u>			9					
647.7810 *647 7810* Bracket A		Manufactured	No				Each	3.0000		4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK077A			3					
					<u>146724</u>			3					
647.7811 *647 7811* Bracket B		Manufactured	No				Each	3.0000		4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK077A			3					
					<u>146725</u>			3					
646.3015 *646 3015* Blade		Manufactured	No				Each	1.0000		8			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					cck103			1					
					<u>147542</u>			1					

NOV 23 2016
DAS 6
9-89

NOV 23 2016
DAS 6
9-89

NOV 23 2016
DAS 6
9-89

NOV 23 2016
DAS 6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Page 2

Wednesday, November 09, 2016 12:45:07 PM

Work Order ID: 153190

153190

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

647.7601

Manufactured No

Each

3.0000

647 7601

Lower Deflector Assembly

**

4 NOV 23 2016
137078

DAS
6
9-89

Location

Loc Qty

Loc Code

cck065

3

148222

3

Each

3.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7815

Manufactured No

647 7815

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

3

138151

3

Each

3.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7814

Manufactured No

647 7814

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

3

138152

3

Each

3.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7816

Manufactured No

647 7816

Aft Bracket

Location

Loc Qty

Loc Code

CCK114

3

138240

3

Each

4.0000

**

3
4

NOV 23 2016

DAS
6
9-89

647.7817

Manufactured No

647 7817

Aft Bracket

Location

Loc Qty

Loc Code

CCK115

4

138364

4

4

Wednesday, November 09, 2016 12:45:07 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Wednesday, November 09, 2016 12:45:07 PM

Work Order ID: 153190

153190

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149FN832P

Purchased

No

Each

1,519.000

104

NAS1149FN832P

Washer

Location

Loc Qty

Loc Code

GA

1389

M133769

89

M135058

1300

ST263

130

M135603

130

MS21042-3

MS21042L3

Purchased

No

Each

0.0000

12

MS21042-3

Nut

MS21042-08

MS21042L08

Purchased

No

Each

0.0000

52

MS21042-08

USE MS21042L08

NAS1149F0332P

Purchased

No

Each

2,822.000

24

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

276

m133709

276

ST260a

2000

m135948

2000

ST262

546

m135544

546

NOV 23 2016

DAS
6
9-89

DAS
36
9-89

16/11/24

104

135767 NOV 23 2016

DAS
6
9-89

135948

NOV 23 2016

24

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Shop Packet Print

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DQA: _____ Date: _____



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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Wednesday, November 09, 2016 12:45:07 PM

Work Order ID: 153190

153190

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-19

Purchased

No

Each

315.0000

28

MS27039-08-19

Screw

DAS
6
9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

182

m135948

182

ST277

133

m135865

33

m136042

100

28

MS27039-1-19

Purchased

No

Each

123.0000

12

MS27039-1-19

Screw

DAS
6
9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

43

m135774

43

12

MS27039-08-24

Purchased

No

Each

281.0000

24

MS27039-08-24

Screw (MS27039-0824)

DAS
6
9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

279

124326

279

ST277

2

125654

2

22

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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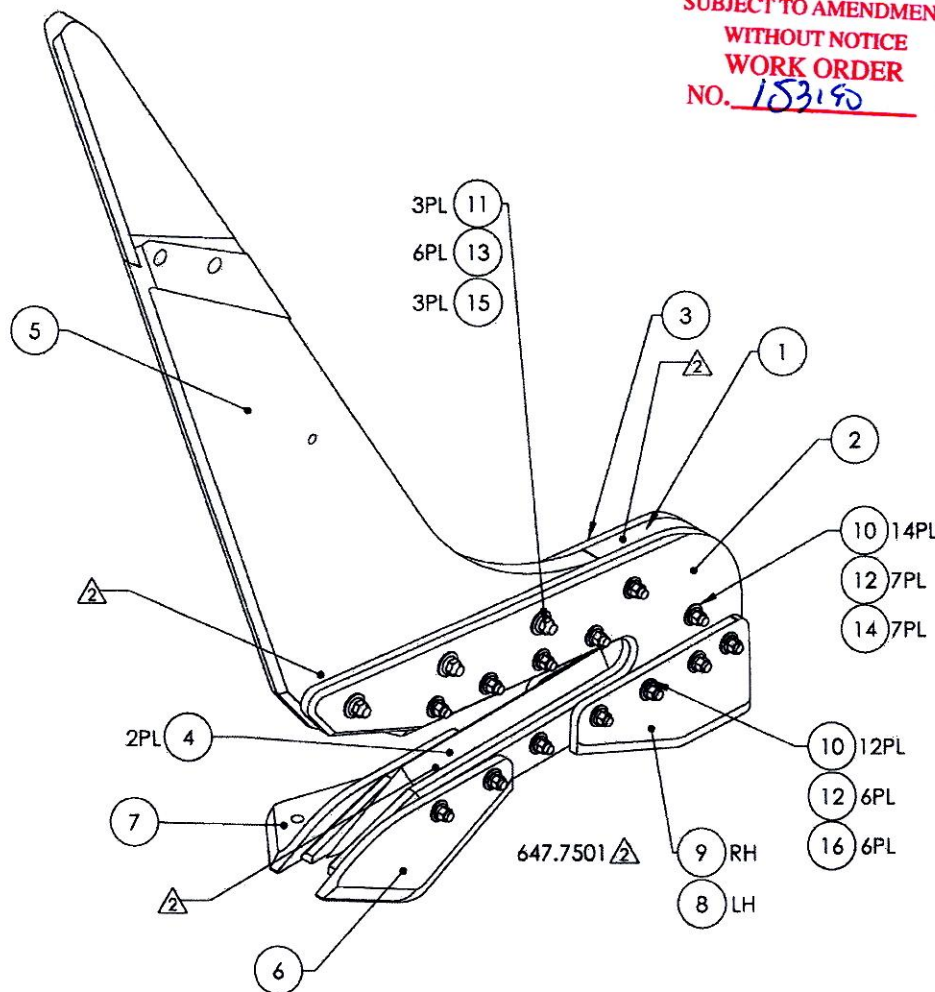
NOTES:

1. IDENTIFY IAW MPP-120

2. APPLY F/N 17 AS REQUIRED TO ALL FAYING SURFACES UPON ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153190

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROJECTIVE REVISION P02		NVC
NVC	INITIAL RELEASE	12/21/07	P. BRAVO
A	INCORPORATED ECH 02/24/08	07-16-10	P. BRAVO



A/R	17	601.2045	RTV, LOCTITE 598		
6	16	601.3124	SCREW	MS27039-0824	
3	15	601.1948	SCREW	MS27039-1-19	
7	14	601.2765	SCREW	MS27039-0819	
6	13	601.1607	WASHER	NAS1149F0332P	
13	12	601.2973	LOCKNUT	MS21042-08	
3	11	601.2943	LOCKNUT	MS21042-3	
26	10	601.2764	WASHER	NAS1149FN832P	
1	9	647.7817	AFT BRACKET		
1	8	647.7816	AFT BRACKET		
1	7	647.7814	FORWARD BRACKET		
1	6	647.7815	FORWARD BRACKET		
1	5	647.7601	LOWER DEFLECTOR ASSY		
2	4	646.3015	BLADE		
1	3	647.7811	BRACKET B		
1	2	647.7810	BRACKET A		
1	1	647.7813	CENTER PLATE LOWER		
7501	FIND #	647.7501	LOWER CUTTER ASSY		2
QTY	7501	PART #	DESCRIPTION	MAT'L	SPEC.

PARTS LIST			
QTY	7501	PART #	647.7501
DESCRIPTION	LOWER CUTTER ASSY		
DATE	11-24-09	CHECKER	P. BRAVO
DRAWN BY	A. QUAN	DESIGNED BY	P. BRAVO
DATE	11-24-09	DATE	11-24-09
UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES		
TOLERANCES ARE:	3 PLACE DECIMALS ± .005		
ANGLES	± .5°		
SCALE	NONE		
SHEET	1 OF 2		

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
LOWER CUTTER ASSY

REV. NO. 647.7500
SCALE NONE
SHEET 1 OF 2

DQA: _____ Date: _____



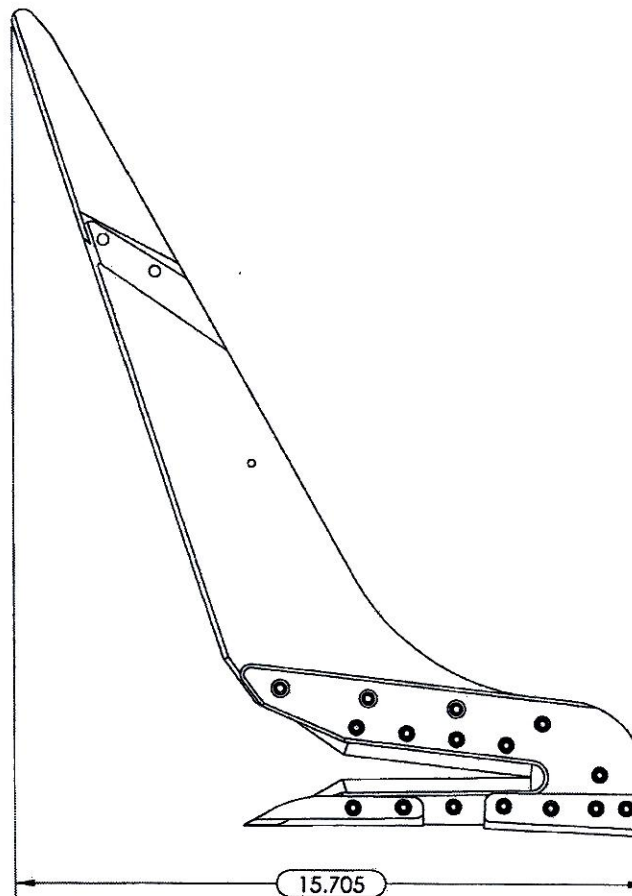
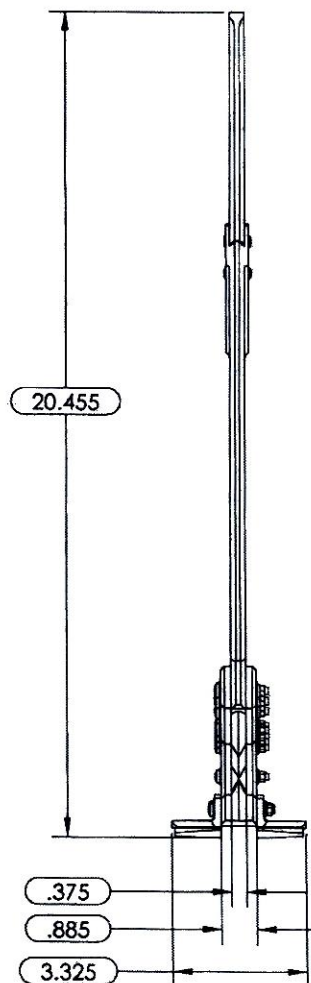
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																				
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ORIGINAL DATE 11-23-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY A. GUAN	CHECKED BY P. BRAVO		
DRAWING APPROVAL P. BRAVO	DATE 05-21-09		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.010 ANGLES ± 5°		REV. A	
SIZE B	CAGE CODE 07M26	DWG. NO. 647.7500	SHEET 2 OF 2
SCALE NONE			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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